

Work Order ID 63783

Monday, November 15, 2010 8:28:43 AM



Page 1

Item ID: D206-558-043

Accept



Setup

Start



Revision ID:

Item Name: Dual Cargo Mirror Assembly

Stop



Start Date: 11/12/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-11-15 Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D206-558

Rev C

100

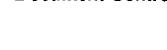


DOCUMENT CONTROL

DC

Memo

Document Control



Photocopy bluefile and create labels per PPP D206-558-043 CHG008

110



Small Fab

Small Fab

Memo

Small Fab

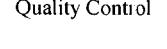
1- assemble as per dwg D206-558

120



Memo

Quality Control



QC5- Inspect part completeness to step on W/O

0.00

0.00

10/11/16

10/11/16 BG 10-11-17

10/11/16 ②

10/11/16

②

10/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Pick Kit

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/11/17



140



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

10 12 03 (2)

150



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D206-558-043
Location: 42
PPP Rev: 14

10/12/17 2017

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Start Date: 11/12/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

10/12/09 J
MF

10-12-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:28:48 AM

Page 1

Work Order ID: 63783



Parent Item: D206-558-043



Parent Item Name: Dual Cargo Mirror Assembly

Start Date: 11/12/2010

Required Date: 11/19/2010

Comments:

IPP G02.09.19 Re-format; Incorporated D2066 KJ

IPP Rev:H 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD verified:

IPP Rev:I 08-08-19 now @ chg 007 DD verified by:ec IPP Rev:J

10.10.27 fixe route seq DD verf:EC

IPP Rev:J

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																																																																																																																																																																																																																																																									
D2066 		Manufactured	No			110	Each	9.0000	 1	 2	 3	 4	 5	 6	 7	 8	 9	 10	 11	 12	 13	 14	 15	 16	 17	 18	 19	 20	 21	 22	 23	 24	 25	 26	 27	 28	 29	 30	 31	 32	 33	 34	 35	 36	 37	 38	 39	 40	 41	 42	 43	 44	 45	 46	 47	 48	 49	 50	 51	 52	 53	 54	 55	 56	 57	 58	 59	 60	 61	 62	 63	 64	 65	 66	 67	 68	 69	 70	 71	 72	 73	 74	 75	 76	 77	 78	 79	 80	 81	 82	 83	 84	 85	 86	 87	 88	 89	 90	 91	 92	 93	 94	 95	 96	 97	 98	 99	 100	 101	 102	 103	 104	 105	 106	 107	 108	 109	 110	 111	 112	 113	 114	 115	 116	 117	 118	 119	 120	 121	 122	 123	 124	 125	 126	 127	 128	 129	 130	 131	 132	 133	 134	 135	 136	 137	 138	 139	 140	 141	 142	 143	 144	 145	 146	 147	 148	 149	 150	 151	 152	 153	 154	 155	 156	 157	 158	 159	 160	 161	 162	 163	 164	 165	 166	 167	 168	 169	 170	 171	 172	 173	 174	 175	 176	 177	 178	 179	 180	 181	 182	 183	 184	 185	 186	 187	 188	 189	 190	 191	 192	 193	 194	 195	 196	 197	 198	 199	 200	 201	 202	 203	 204	 205	 206	 207	 208	 209	 210	 211	 212	 213	 214	 215	 216	 217	 218	 219	 220	 221	 222	 223	 224	 225	 226	 227	 228	 229	 230	 231	 232	 233	 234	 235	 236	 237	 238	 239	 240	 241	 242	 243	 244	 245	 246	 247	 248	 249	 250	 251	 252	 253	 254	 255	 256	 257	 258	 259	 260	 261	 262	 263	 264	 265	 266	 267	 268	 269	 270	 271	 272	 273	 274	 275	 276	 277	 278	 279	 280	 281	 282	 283	 284	 285	<img alt="Barcode for 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 63783



Parent Item: D206-558-043



Parent Item Name: Dual Cargo Mirror Assembly

Start Date: 11/12/2010

Required Date: 11/19/2010

D2053

Manufactured No 130 Each 18.0000

Start Qty: 2.00

Required Qty: 2.00

Mounting Bracket



1 2
D11117 SP

AN3-4A

Purchased No 130 Each 1,075.000



2 4 8
10/11/17 SP

Bolt

Location	Loc Qty	Loc Code
ST005	18	
58395	18	

AN526-1032R9

Purchased No 130 Each 134.0000



8 4 8
10/11/17 SP

Screw

Location	Loc Qty	Loc Code
ST350	1075	
104214	72	
104291	300	
104322	200	
104374	200	
104625	300	
104817	3	

AN960JD10L

Purchased No 130 Each 0.0000



6 12
M1141884 10/11/17 SP (2X)

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, November 15, 2010 8:28:48 AM

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Work Order ID: 63783



Parent Item: D206-558-043



Parent Item Name: Dual Cargo Mirror Assembly

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

MS21042L3



Purchased

No

130

Each

1,783.000



1
2
10/11/17 sf

XL Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1783	
114784	783	
115835	1000	

MS21919-DG5



Purchased

No

130

Each

52.0000



2
4
10/11/17 sf

XL Clamp

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST306	50	
115698	50	
ST307	2	
114988	2	

MS35489-9



Purchased

No

130

Each

73.0000



1
2
10/11/17 sf 20

Grommet

XL

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST296	73	
109371	73	

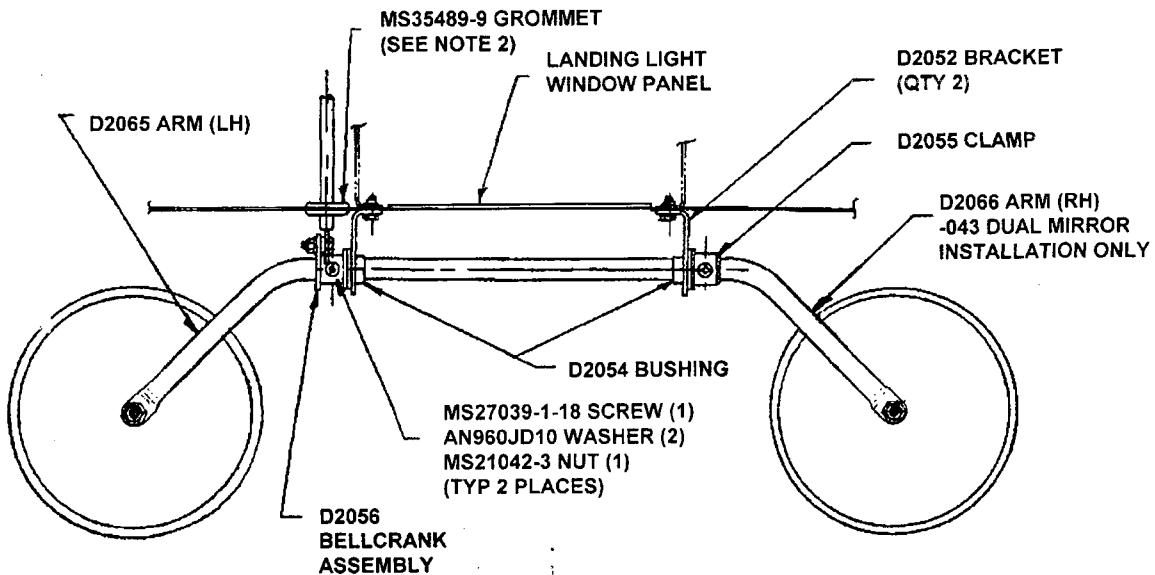
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63783

BD 10-11-15

Figure 25.2 – View A: Looking Aft.
(D206-558-043 Mirror Shown)

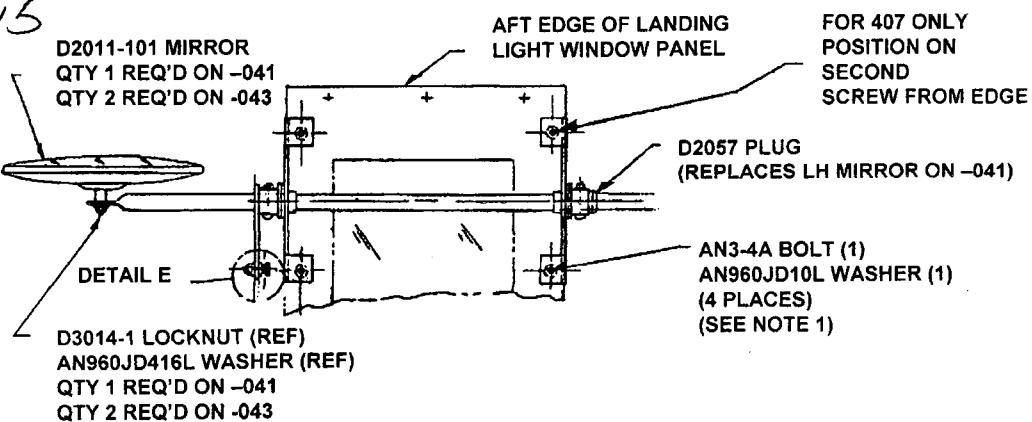


Figure 25.3 – View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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25-00-00

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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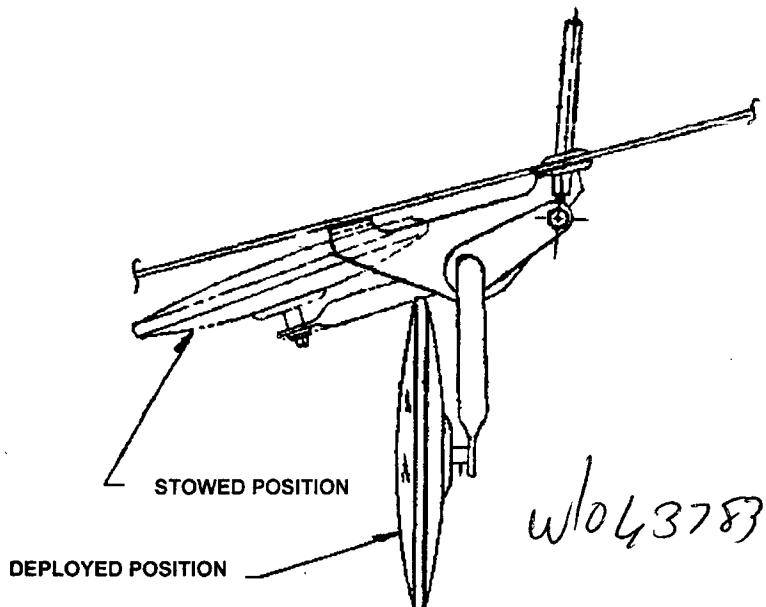


Figure 25.4 – Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)

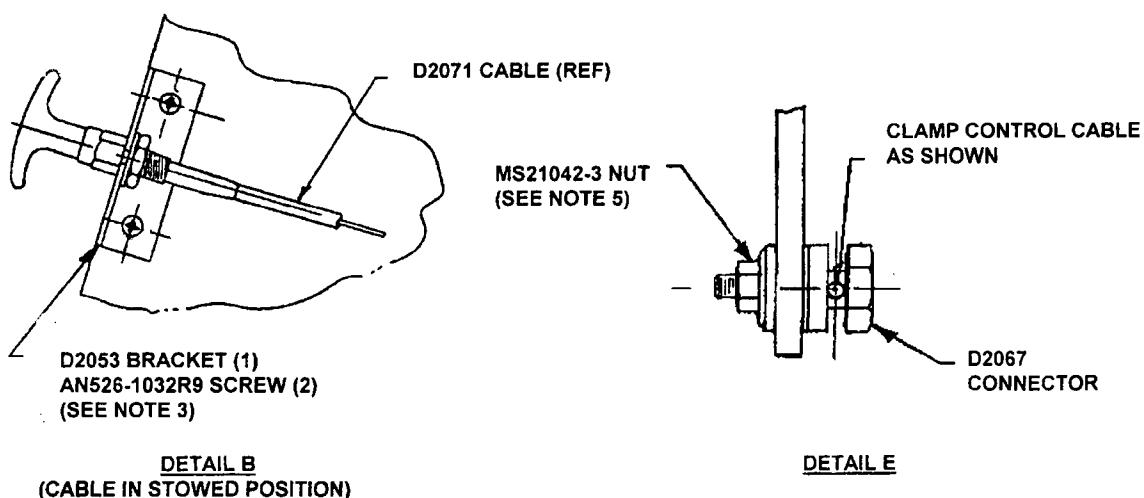


Figure 25.5 – Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)

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25-00-00

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041 Bell 206A/B/L/L1/L3/L4 Bell 407	2.4 lb 1.09 Kg	+5.0 in +0.13 m	+12.0 in-lb +0.14 m-Kg	+14.8 in +0.38 m	+35.5 in-lb +0.41 m-Kg
D206-558-043 Bell 206A/B/L/L1/L3/L4 Bell 407	3.0 lb 1.36 Kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-Kg	+14.8 in +0.38 m	+44.4 in-lb +0.52 m-Kg

5.0 WEIGHT AND BALANCE

Qty -041	Qty -043	Part Number	Description
X		D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X	D206-558-043	DUAL CARGO MIRROR ASSEMBLY
1	2	D3014-1	* LOCKNUT
1	1	D2071	CABLE ASSEMBLY
2	2	D2054	BUSHING
1	1	D2067	CONNECTOR
	1	D2066	ARM
1		D2065	ARM
1		D2057	PLUG
1	1	D2056	BELLCRANK ASSEMBLY
1	1	D2055	CLAMP
1	1	D2053	BRACKET
2	2	D2052	BRACKET
1	2	D2011-101	MIRROR ASSEMBLY
4	4	AN3-4A	BOLT
4	4	AN526-1032R9	SCREW
1	2	AN960JD416L	* WASHER
4	4	AN960JD10	WASHER
6	6	AN960JD10L	WASHER
3	3	MS21042-3	NUT (or MS21042L3)
2	2	MS21919DG5	CLAMP
2	2	MS27039-1-18	SCREW
1	1	MS35489-9	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY